

D

C

B

A

DESCRIPTION MATERIAL MAT. LOCATION

NOTES: (UNLESS OTHERWISE SPECIFIED)

- THIS IS A CRYOGENIC VACUUM COMPONENT.
- WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS:
PER VENDOR SPCIFICATION WITH LBNL APPROVAL.
- DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982.
UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
- USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS,
OR COOLANTS ARE STRICTLY PROHIBITED.
- USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER
IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES
ONLY.
- VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBECT TO
LBNL APPROVAL.
- ELBOWS MAY BE USED ON THE TUBE BENDS AS NEEDED.
- VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE
FABRICATION OR ASSEMBLY; SUBECT TO LBNL APPROVAL.
- REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY
AND CLEAN ENDS.
- TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS
WITHIN +/- .010.
- PERFORM ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL
SPECIFICATION M856.
- MATERIAL IS 300 SERIES STAINLESS STEEL PER VENDOR
SPECIFICATION AND SUBJECT TO LBNL APPROVAL. ALLOY
MUST BE COMPATIBLE WITH WELDING TO 304L STAINLESS
STEEL TUBING.

SCALE 1/4

Ø.750 [19.05] TUBE X
.049 [1.24] WALL

7.45 [189.3]
2.25 [57.2]
7.00 [177.8]

DIRECTION OF THERMAL CONTRACTION
1" [25.4] TRAVEL FROM SHOWN POSITION

REV	DWG	CHK	ZONE	DATE	CHANGES
A		DPO			CHANGES PER PRODUCTION READINESS REVIEW

TOLERANCES		UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER NO.
X.X ± 0.1	FRACTION ± 1/64	ACCT NO.	NO. REQD	DATE ISSD	DATE RECD	-
X.XX ± 0.03	Angles ± 1.00°	DEL TO				
X.XXX ± 0.010	FINISH \sqrt{Ra}	SURFACE TREATMENT				
DO NOT SCALE PRINT		IDENT METHOD TAG				
THREADS ARE CLASS 2		PROJECT NUMBER	N/A			
CHAMFER ENDS OF ALL SCREW THREADS 30°		PROJECT NAME	N/A			
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		DWG BY D. REAVILL	DATE 30-JUL-02			
BREAK EDGES .016 MAX. ON MACHINED WORK		CHK BY J. ZBASNIK	DATE 30-JUL-02			
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		APR BY J. ZBASNIK	DATE 30-JUL-02			
IN ACCORDANCE WITH ASME Y14.5M & B46.1						

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY				UNIVERSITY OF CALIFORNIA - BERKELEY	
LHC IR FEEDBOX CRYOGENICS					
BRAIDED FLEX HOSE, .625" ID X 3/4" STRAIGHT ENDS, 17.72" LL					
MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE:	DO NOT SCALE PRINTS	
PART	VARIOUS		1/2		
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE	REV.
Z5LC2	LH2003		25i6563	A	

SHEET 1 OF 1

Doc File: 25i6563.dwg Plot Date: 25JUL02